

Work Order ID 151964

Friday, October 14, 2016 1:56:12 PM

151964

Page 1

Item ID: D3884-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Inside RH

Start Date: 10/31/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/4/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: **DAS** Date: **OCT 17 2016**

Tooling:

Date:

Run Start ***NR1***QC: **21**
9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3884	C
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100

0.03

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.63

HAAS CNC vertical machine #1

Program Batch No. **151964**Double check by: **mmf**

1-Machine Step No 1 per Folio FA819 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA819 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA819 and inspect per Dimension Sheets

12**0****DAS**
20
9-89**16-11-07**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

12**0****DAS**
20
9-89**16-11-07**

Friday, October 14, 2016 1:56:12 PM

151964

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Saddle, Inside RH

Start Date: 10/31/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 11/4/2016 **Req'd Qty:** 4.00 ****A****

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

Insp.
Stand.

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.01

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.08

Hand Finishing

Work Order ID 151964

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151964

Page 3

Item ID: D3884-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Inside RH
Start Date: 10/31/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 11/4/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo <u>11/34798.</u>	0.02							
Powder Coating	***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)***								
	DO NOT MASK INSIDE FLANGE SURFACE								
	START TIME: <u>8:25</u>								
	OVEN TEMPERATURE: <u>350°</u>								
	FINISH TIME: <u>10:55</u>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.01							
Quality Control									

12 ϕ 16-11-8. DAS 34 9-89

12 DAS 38 9-89

NOV 08 2016

Work Order ID 151964

Friday, October 14, 2016 1:56:12 PM

151964

Page 4

Item ID: D3884-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Inside RH

Start Date: 10/31/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/4/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: *St 404*

0.00

160

Packaging

Memo

0.01

12 NOV 09 2016DAS
6
9-89

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.07

16/11/9 *JD*

Quality Control

DAS
21
9-89

NOV 09 2016

Picklist Print

Friday, October 14, 2016 1:56:11 PM

Page 1

Work Order ID: 151964

151964

Parent Item: D3884-2

D3884-2

Parent Item Name: Saddle, Inside RH

Start Date: 10/31/2016

Required Date: 11/4/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-017		Manufactured	No				Each	33.0000		4			
D6101-017									**				
Saddle Billet													

Location

Loc Qty

Loc Code

MAT046

33

144956

3

149294

10

151100

20

DAS
44
9-89

16-11-02.

1
10
1

DART AEROSPACE LTD		Work Order:	151964
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. C	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.641	.643	.641	.644		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.612	.612	.612	.612		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		.152	.151	.152	.151		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		.125	.125	.125	.125		
M	0.240	0.260		.251	.250	.250	.251		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.252	.250	.249	.253		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.152	.151	.151	.152		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.493	.499	.499	.500		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.314	.314	.314	.314		
AA	0.760	0.765		.761	.761	.761	.761		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		.998	.998	.998	1.000		
AF									
Accept/Reject							DAS		
							49		

Measured by:	
Date:	16-11-06

Audited by:	
Date:	16/11/07

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	151964
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. C		
		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.642	.643	.644	.642		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.613	.612	.613	.612		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		.152	.150	.150	.150		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		.125	.125	.125	.124		
M	0.240	0.260		.250	.250	.250	.249		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.252	.254	.253	.255		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.152	.152	.152	.151		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.499	.499	.500	.499		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.314	.314	.314	.314		
AA	0.760	0.765		.761	.761	.761	.761		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.000	1.001	1.001	1.001		
AF									
Accept/Reject							DAS		

Measured by:	20
Date:	16-11-06

Audited by:	9-89
Date:	16/11/07

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																			
Misidentified ☐	Past Due ☐																				

DART AEROSPACE LTD		Work Order:	151964
Description: Saddle, Inboard, RH		Part Number:	D3884-2
Inspection Dwg: D3884	Rev. C		
		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	11	12		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.644	.645	.643	.643		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.258	.258	.258	.258		
F	0.605	0.625		.614	.614	.612	.613		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.175		.149	.148	.151	.150		
K	1.265	1.285		1.265	1.265	1.265	1.265		
L	0.115	0.135		.125	.126	.124	.125		
M	0.240	0.260		.250	.250	.249	.250		
N	0.110	0.140		.140	.140	.140	.140		
O	0.240	0.260		.256	.253	.254	.253		
P	2.826	2.886		2.856	2.856	2.856	2.856		
Q	0.178	0.198		.188	.188	.188	.188		
R	0.140	0.165		.152	.151	.152	.151		
S	0.720	0.780		.760	.760	.760	.760		
T	1.220	1.280		1.250	1.250	1.250	1.250		
U	1.245	1.255		1.250	1.250	1.250	1.250		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	2.495	2.505		2.500	2.500	2.500	2.500		
X	0.490	0.510		.499	.500	.5005	.497		
Y	0.020	0.040		.030	.030	.030	.030		
Z	0.313	0.318		.314	.314	.314	.314		
AA	0.760	0.765		.761	.761	.761	.761		
AB	0.215	0.220		.218	.218	.218	.218		
AC	0.316	0.321		.316	.316	.316	.316		
AD	1.745	1.755		1.750	1.750	1.750	1.750		
AE	0.990	1.010		1.001	1.001	1.001	1.0015		
AF									
Accept/Reject								DAS	

Measured by:	20
Date:	16-11-06

Audited by:	9-89
Date:	16/11/07

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	
B	15.09.09	Dwg Rev updated	KJ	

DQA: _____ Date: _____

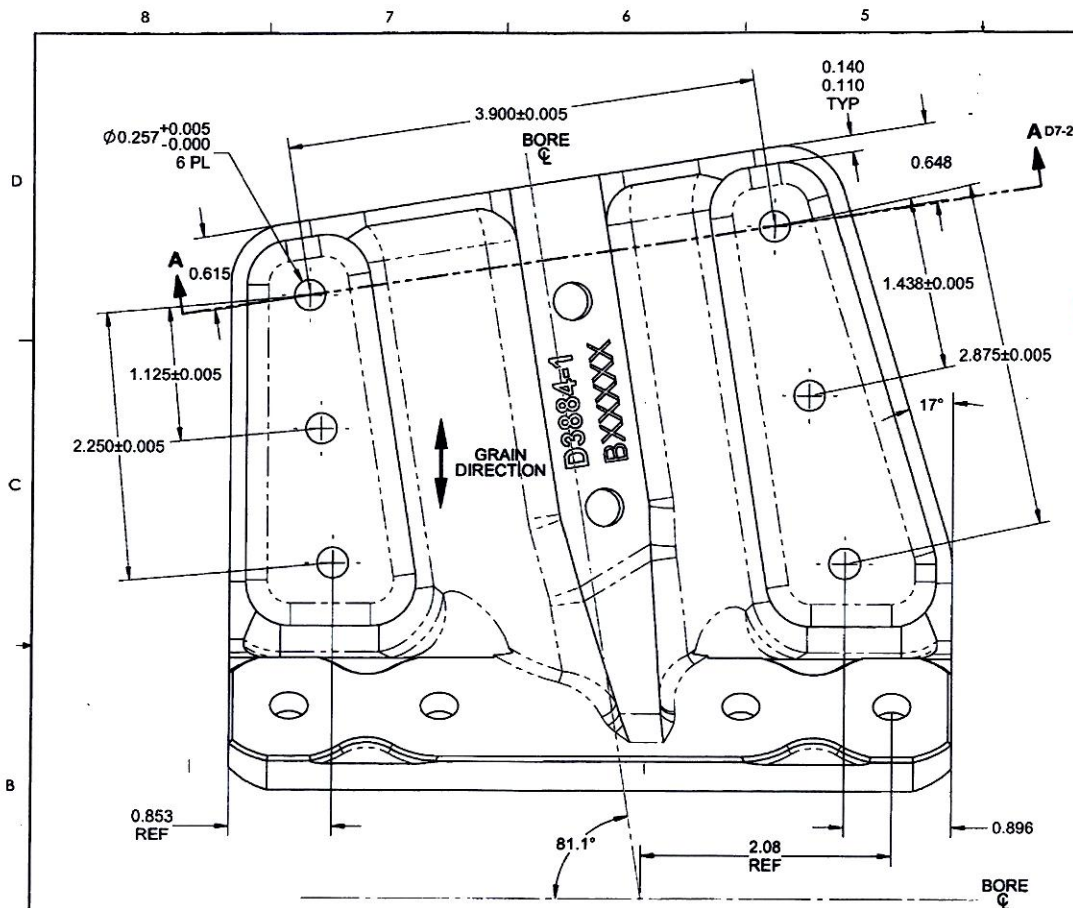


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

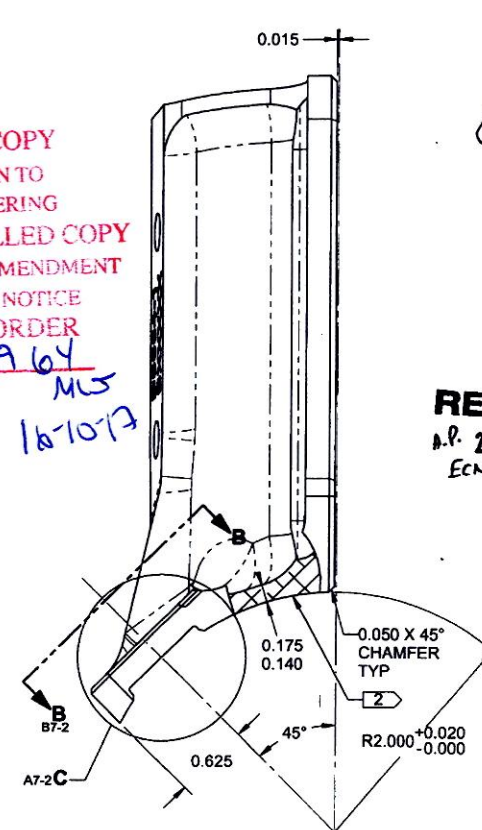


D3884-1 SADDLE, INBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3884-1-REVC.SLDPR"™

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151964
ML5
16-10-17



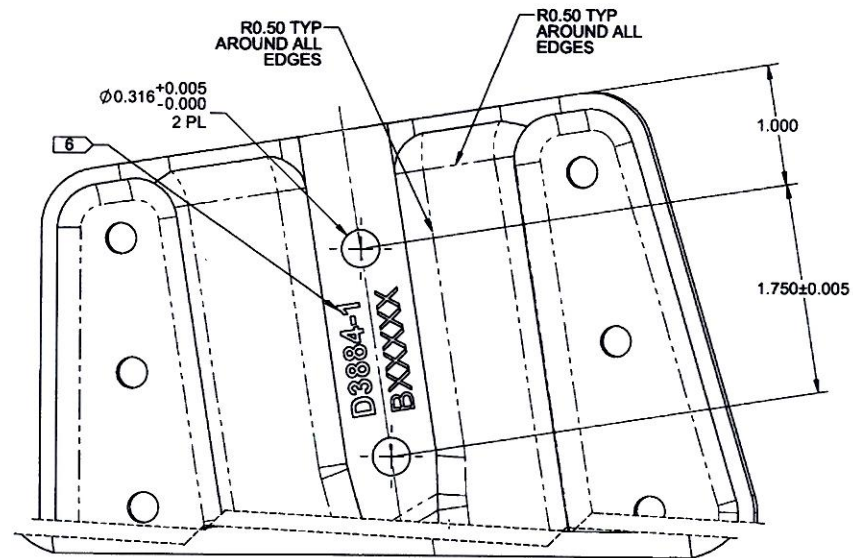
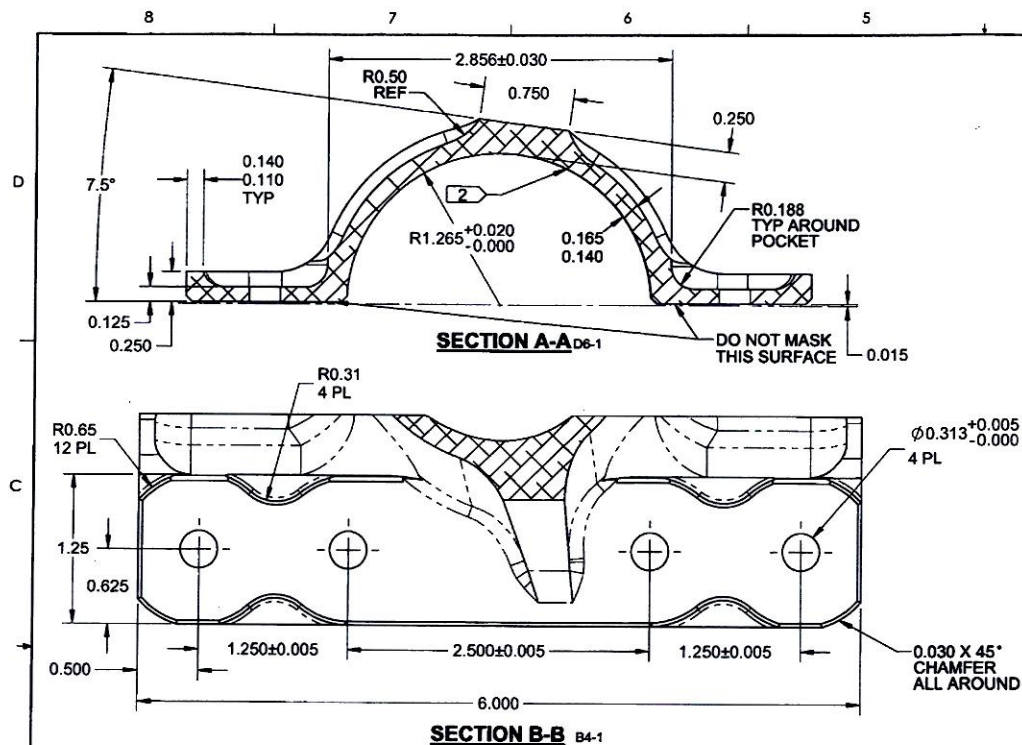
RELEASED
A.P. 2015 MAY 19
ECN15-575

C	GENERAL REDRAW & REMOVED UNNECESSARY DIMS; ADDED NOTE 9, REMOVED POWDER COAT FROM INSIDE SURFACE OF D3884-1/2, ADDED D3884-2 TO SHT 3 & 4.	AP	15.02.11
B	D6101-017 WAS D6102-017. ZN A6-1; ADD NOTE ZN C4-2; ADD R0.031 ZN C2-2; INCREASED TOLERANCE 0.175 WAS 0.165 ZN B7-1; ADD 0.615 ZN C6-1; ADD 0.648 ZN C4-1; ADD 0.250 ZN D6-2; ADD 0.060 ZN C2-2; 0.75 WAS 0.65 ZN D7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP		
DRAWN	AP		
CHECKED	AJS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	15.02.11		

DART AEROSPACE USA, INC.
KENT, WA

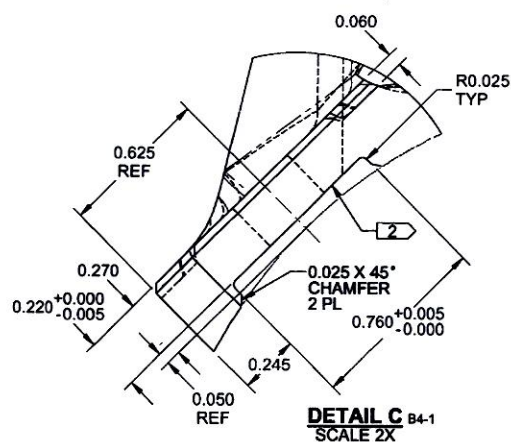
DRAWING NO. **D3884** REV. C
SHEET 1 OF 4
TITLE **INBOARD SADDLE** SCALE NTS

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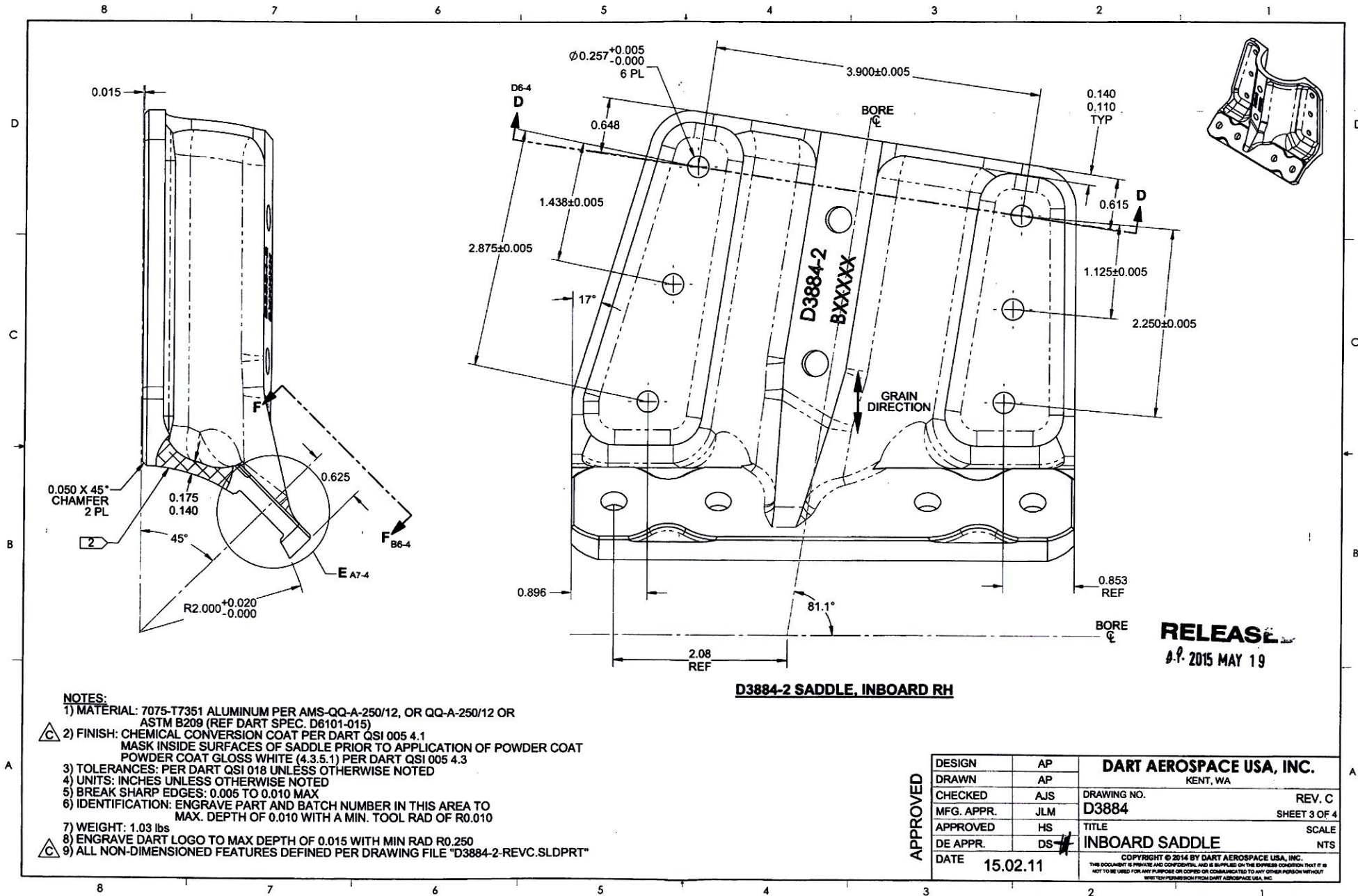
D3884-1 SADDLE, INBOARD LH
(AUXILIARY VIEW)

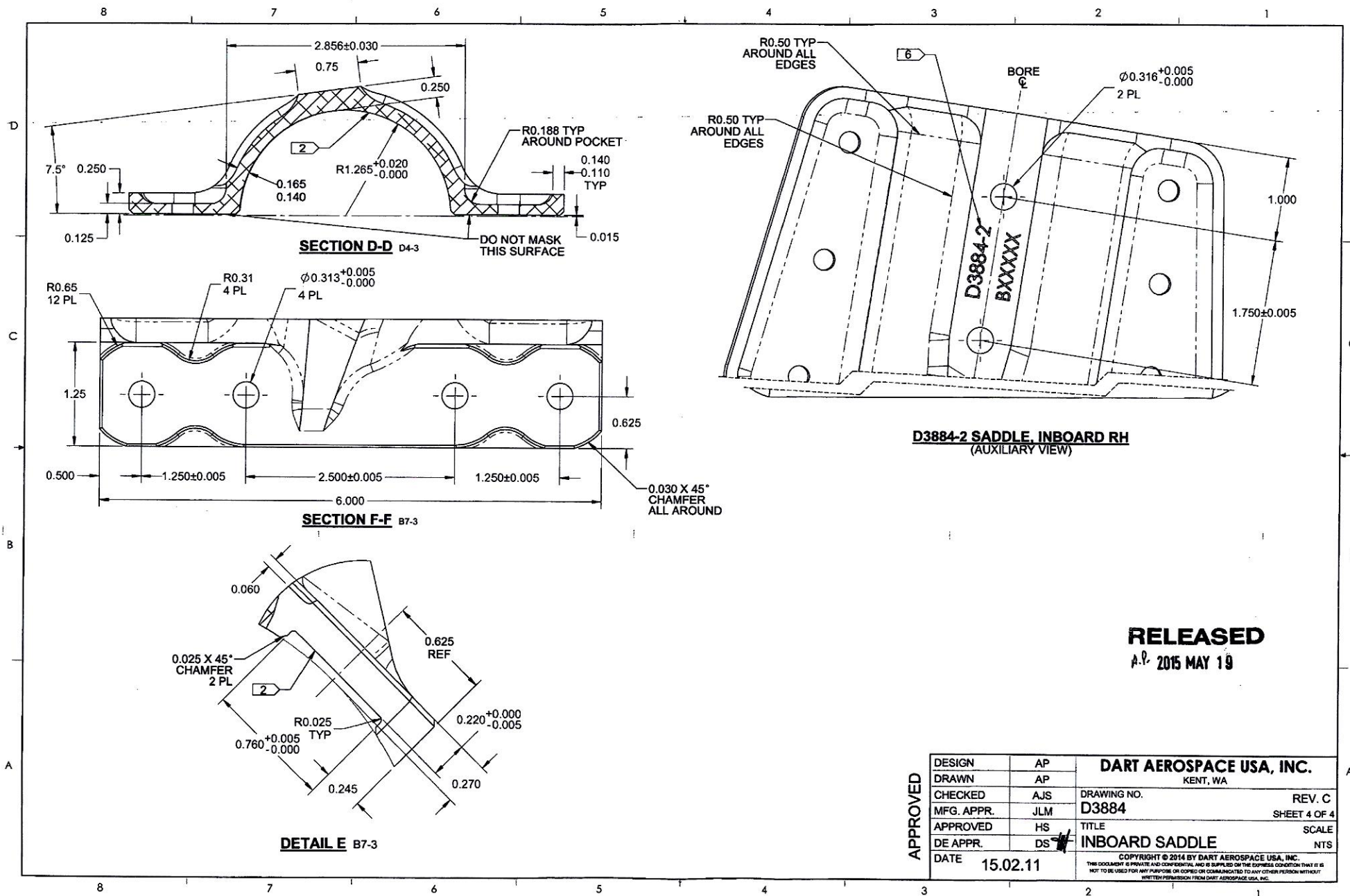
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